

Work Order ID 70447

Wednesday, June 15, 2011 7:14:29 AM

Page 1

Item ID: D4055-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Tank Aft End

Start Date: 6/8/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4055

B

100

0.00

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D4055

Prog rev:

Dwg rev:

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

QC

Memo

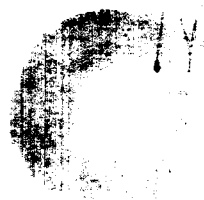
0.00

Quality Control

B11-6-14

B11-6-14

Subtotal



Work Order ID 70447

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Item ID: D4055-3

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Start Date: 6/8/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

SB 11/06/24

①

140

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

S 11/06/24

②

150

Identify as per dwg & Stock Location: WA 14 0.00

Packaging

Memo

0.00

Packaging

K 11.06.30

1 ③

P.T.O.

11-06-29	171	Chemical Concentration Cont per BRISOS H ₂	11-06-29	1	11-06-29	QCS - Inspect parts finish
11-06-29	142					

W/O: 70447		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11/6/30	#140	Perm. change the chemical cost as per Day	SP	11-20-30	1	[Signature]	11/6/30	
	#142	Qc3 inspect chemical cost	[Signature]	11/6/30	1	[Signature]	11/6/30	

Part No: D4055-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70447

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Item ID: D4055-3

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Setup Start



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Item Name: Tank Aft End

Start Date: 6/8/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/30 [Signature]

11-06-30

Picklist Print

Wednesday, June 15, 2011 7:14:26 AM

Page 1

Work Order ID: 70447

Parent Item: D4055-3

Parent Item Name: Tank Aft End



Start Date: 6/8/2011

Required Date: 6/17/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM
10.11.23 now made in house DD verf:EC

IPP rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased		No		100	sf	251.6700	1.5143	1.594			
											B116-14		

6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT021

251.67

116308

29

117285

222.67

17288

DART AEROSPACE LTD		Work Order: 76447
Description: TANK AFT END		Part Number: D4055-3
Inspection Dwg: D4055-3, Rev: 9 8		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

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
First Article

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Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.625	+0.012 - .001	1.626	2		V B02	
.59	±.030	.595	2		V	
9.23	±.030	9.23	2		T B01	
9.82	±.030	9.82	2		T	
.65	±.030	.648	2		V	
20.96	±.030	20.96	2		T	
21.02	±.030	21.02	2		T	
21.55	±.030	21.55	2		T	
23.34	±.030	23.34	2		T	
25.34	±.030	25.34	2		T	
25.93	±.030	25.93	2		T	
25.40	±.030	25.40	2		T	
2.22	±.030	2.220	2		V	
5.13	±.030	5.13	2		V	
5.72	±.030	5.730	2		V	
7.17	±.030	7.174	2		V	
7.76	±.030	7.77	2		V	
.063	±.010	.061	2		V	

Measured by: B
Date: 11-6-14

Audited by: 
Date: 11/06/14

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

